

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 13.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008457**Date Inspected:** 14-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 2100**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 530**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, Oregon

CWI Name:	Jon Nickolich		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** Hinge K Pipe Beams**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Oregon Iron Works, Inc. (OIW) jobsite in Clackamas, Oregon for the purpose of observing fabrication of the Hinge K Pipe Beams.

OIW Fabrication Shop-Bay 3 (sub-assembly):

QA Inspector Brannon randomly observed OIW qualified welder Mr. Ron Kent ID#K19 welding fill pass's joining stiffener MK #a107 (HPS 485 W) to stiffener MK#a106 (HPS 485 W) for hinge k pipe beam base assembly section 102A-1. The fillet weld is identified as weld joint #W1-91. Mr. Kent was observed welding in the 1F (flat) position utilizing submerged arc welding (SAW) process with a 2.4mm diameter electrode, filler metal brand Lincoln Electric LA85 class F9A4-Eni5-G-H2. QA Inspector Brannon observed the OIW QC CWI Inspector Mr. Jon Nickolich verifying that the pre-heat of 350°F and welding parameters were in accordance with the Welding Procedure Specification (WPS). Welding parameters measured by QA are as follows for fill: 563 amps, 36.4 volts and a travel speed of 508mm per minute appear to be in conformance with approved welding procedure specification WPS 4020 revision number 2.

OIW Fabrication Shop-Bay 3 (sub-assembly):

QA Inspector Brannon randomly observed OIW qualified welder Mr. Jose Camara ID#C33 welding fill pass's joining stiffener MK #a107 (HPS 485 W) to stiffener MK#a106 (HPS 485 W) and stiffener MK #c106 (HPS 485 W) to stiffener MK#a106 (HPS 485 W) for hinge k pipe beam base assembly section 102A-1. The fillet welds are identified as weld joint #W1-02 and #W1-06. Mr. Camara was observed welding in the 1F (flat) position utilizing submerged arc welding (SAW) process with a 2.4mm diameter electrode, filler metal brand Lincoln Electric LA85 class F9A4-Eni5-G-H2. QA Inspector Brannon observed the OIW QC CWI Inspector Mr. Jon Nickolich verifying

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that the pre-heat of 350°F and welding parameters were in accordance with the Welding Procedure Specification (WPS). Welding parameters measured by QA are as follows for fill: 570/571 amps, 35.8/36.0 volts and a travel speed of 508mm per minute respectively appear to be in conformance with approved welding procedure specification WPS 4020 revision number 2.

OIW Storage

Hinge-K Pipe Beam Sub Assembly, MK#120A-3 – MK#a124-10 half fuse to MK#a124-12 half fuse.

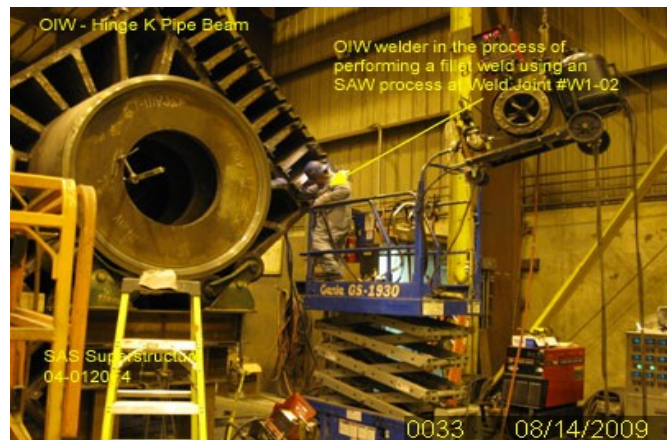
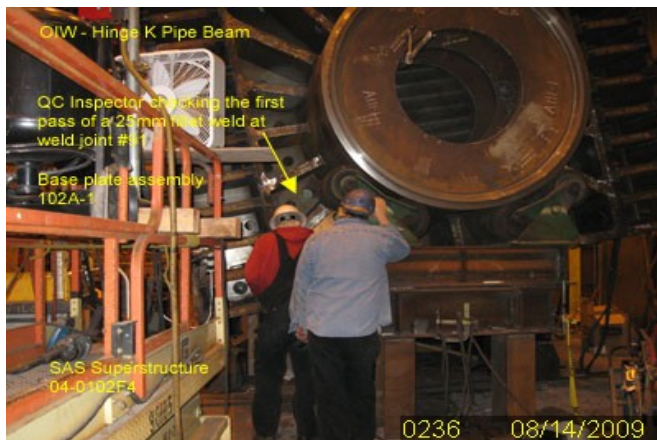
Caltrans Status and Production Tracking:

QA Inspector Brannon also updated Caltrans status and production tracking logs for tracking of check samples, procedure qualification record (PQR), critical weld repairs (CWR), non-critical welding repairs (WRR), completed and in process welding, QC/QA non-destructive testing.

Material, Equipment, and Labor Tracking:

QA Inspector Brannon performed a verification of personnel at OIW. QA Inspector Brannon observed 1 Supervisor, 1 Quality Control and 2 production personnel on this date.

The following digital photograph below illustrates observation of the activities being performed.



Summary of Conversations:

As noted within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Adame, Joe

QA Reviewer